

# Work Order ID 56825

March 10, 2010 3:48:56 PM



Page 1

Item ID: D3566-1

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 10/03/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: H

Date: 10-3-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3566

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3566 ☒ Dwg Rev: C ☐ Prog Rev: C ☐ 2-  
Deburr if necessary

10-3-18



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-3-8

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8:10/03/19



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Identify as per dwg & Stock Location

FP15

0.00

Packaging

Memo

0.00

Packaging

103-19 SP 22

140



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/03/24 JF

CL 10/3/19

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

March 10, 2010 3:49:01 PM

Page 1

Work Order ID: 56825



Parent Item: D3566-1



Parent Item Name: Gasket

Start Date: 10/03/2010

Required Date: 17/03/2010

Comments: IPP Rev:A New Issue 07-03-08 ec  
IPP Rev:B Added Drain Holes 07-07-09 JLM  
IPP Rev:C As per Rev C 07-09-09 JLM Verified By:EC

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ MNEO60S.063	Replacement	Mfg/ Purchased	Bin No	Primary	Last	Route 100	Unit of sf	Qty on 121.3105	Remaining 19.1789	Qty 20,	Date	Status
NEOPRENE SHEET 0.063												



B 10-3-18

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

113058

121.3105

121.3105

113058

22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	56825
<b>Description:</b> Gasket		<b>Part Number:</b>	D3566-1
<b>Inspection Dwg:</b> D3566 <b>Rev:</b> C		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.10	+/-0.030	3.102	✓			
18.00	+/-0.030	18.00	✓			
12.10	+/-0.030	12.10	✓			
2.43	+/-0.030	2.436	✓			
6.00	+/-0.030	6.00	✓			
1.40	+/-0.030	1.401	✓			
0.30	+/-0.030	0.303	✓			
0.30	+/-0.030	0.303	✓			
0.063	+/-0.010	0.062	✓			
Ø0.188	+0.005/-0.001	0.190	✓			

<b>Measured by:</b> B	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-3-18	<b>Date:</b> 10/03/19	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	
B	07.07.18	Dimensions updated per Dwg Rev. B	KJ/JLM	
C	07.09.26	Dwg Rev updated	KJ/EC/DD	EE

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

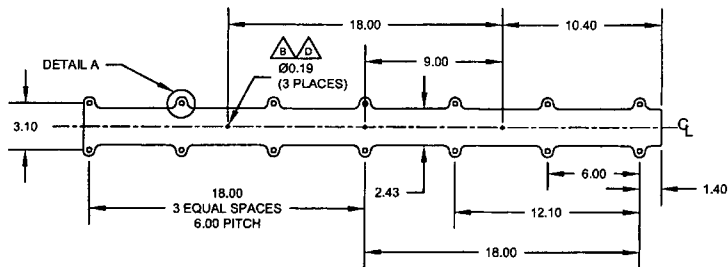
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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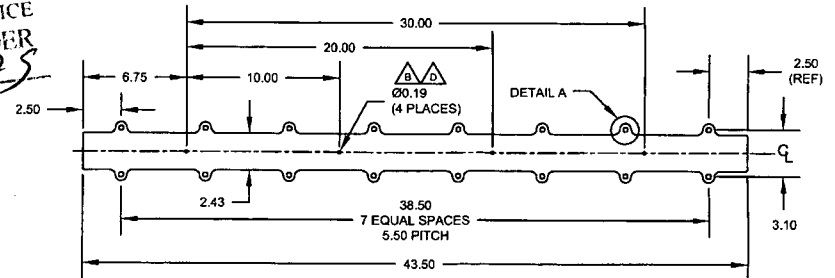
**NOTE:** Date & initial all entries



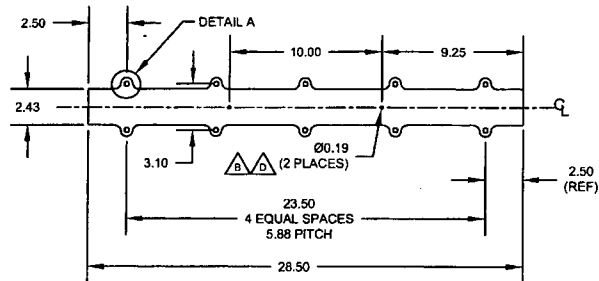
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 54825  
P110-311



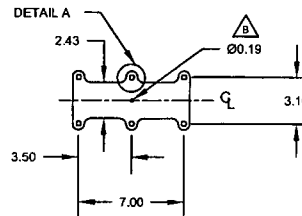
**D3566-1 GASKET**



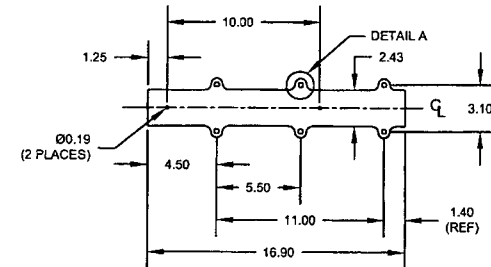
**D3566-5 GASKET**



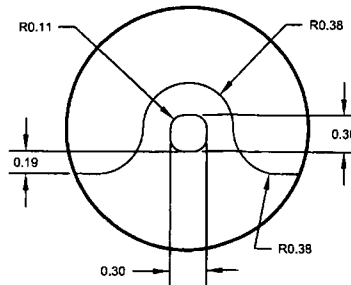
**D3566-7 GASKET**



**D3566-13 GASKET**



**D3566-15 GASKET**



**DETAIL A**  
SCALE 1:1

**WEIGHTS:**

D3566-1	0.29 lbs
D3566-5	0.36 lbs
D3566-7	0.24 lbs
D3566-13	0.07 lbs
D3566-15	0.15 lbs

- NOTES:**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC M-NEO60-S.063)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: SEE TABLE IN ZONE A3
  - 8) PARTS ARE SYMMETRIC ABOUT Q

**RELEASED**

07.08.04

C	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); A8: UPDATE NOTES; A8, B2: ADD D3566-15; A5: INCREASE SIZE OF DETAIL A;	CB	07.08.21
B	ADD DRAIN HOLES	PH	07.04.17
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH	DRAWING NO. D3566 TITLE GASKET SCALE 1:8	
DATE	07.08.21	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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